

Date: Monday, 23/03/2009 9:54:38 AM  
User: Julie Dawson

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CLAMP
<b>Job Number</b> :	46659		
<b>Estimate Number</b> :	13264		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3777041
<b>This Issue</b> :	23/03/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3777 REVA
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43366	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	31/03/2009
<b>Written By</b> :		<b>Qty:</b>	4
<b>Checked &amp; Approved By</b> :	<u>JUD 0903.23</u>	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A new issue 08-05-26 DD verified by:EC Est Rev:B 08-10-20 revA as per dwg DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S22GA	304/316 .032 Sheet
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**Comment:** Qty.: 0.0210 sf(s)/Unit Total : 0.0840 sf(s)  
304/316 .032 Sheet  
Batch: 109057 B9-4-22

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3777-1  
Dwg Rev: A B9-4-22  
Prog Rev: A  
  
2-Deburr if necessary



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Ser 64/22 (32) counts

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
1- Deburr any rough edges  
2- Form as per Dwg D3777

- m-h 09/04/22 (32)  
Ser 09/04/24 (32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/03/2009 9:54:38 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 46659

Part Number: D3777041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorter/24 (32) units

7.0

D2182B013

Rubber cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

batch:

B42737

(14X)

B39986

(18X)

Ep09/04/27

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: Assemble rubber cushion as per dwg D3777

Ep09/04/27

(32)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorter/28 (32) units

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST133

SS 09/04/29 (32)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/29

Job Completion



MF 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

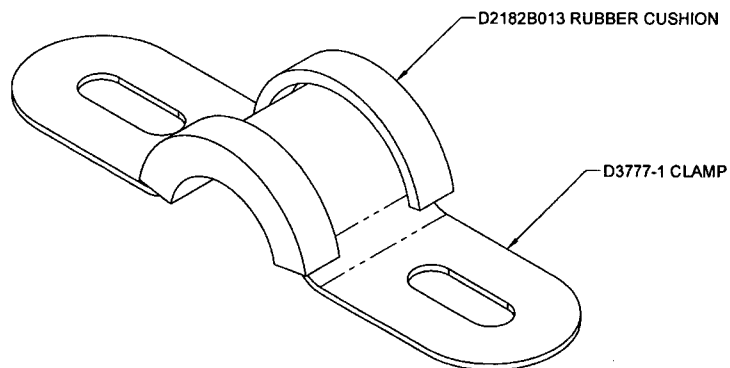
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY	P/N	DESCRIPTION
-041		
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



**D3777-041 CLAMP**

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 1405

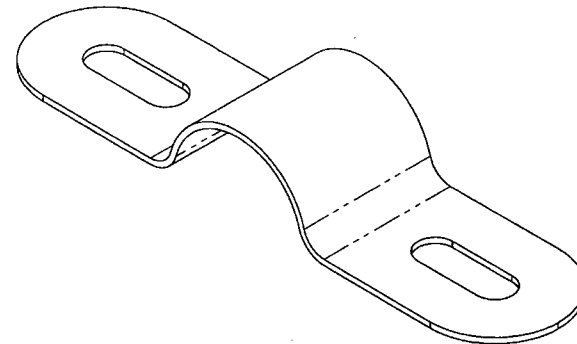
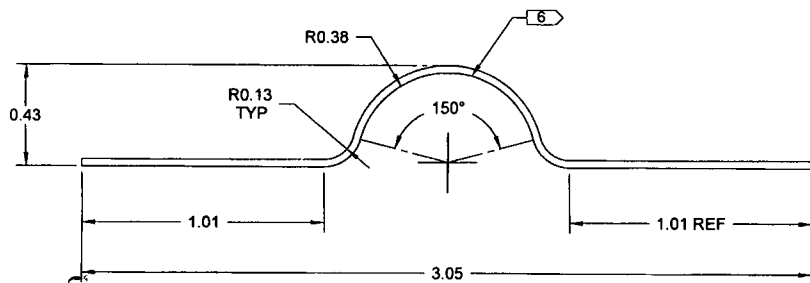
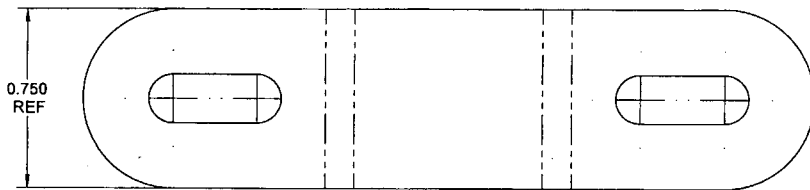
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

**RELEASED**  
08-10-15-11

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	MD	D3777	SHEET 1 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	CLAMP	NTS
DATE	08.04.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



**D3777-1 CLAMP**

NO. 4689  
 V. P. R.  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 RETURN TO  
 ENGINEERING  
 SHOP COPY

- NOTES:
- 1) MATERIAL: MAKE FROM D3777-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1" USING FINE POINT PERMANENT MARKER
  - 7) WEIGHT: 0.02 lbs

**RELEASE**  
 08-10-15

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	MD	<b>D3777</b>	SHEET 2 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	W	<b>CLAMP</b>	NTS
DATE	08.04.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

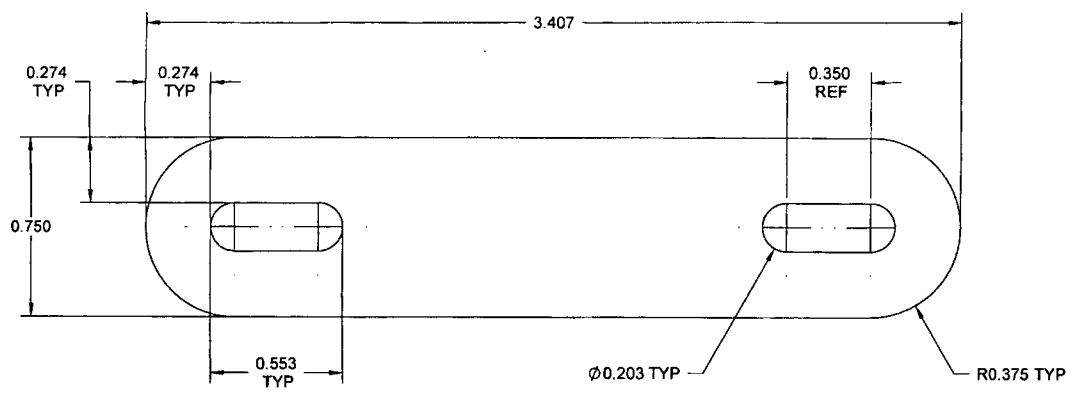
C

B

B

A

A



**D3777-1F CLAMP**

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. *40059*

**RELEASED**  
*08-10-15*

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

DESIGN	<i>92</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>92</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>WV</i>	<b>D3777</b>	SHEET 3 OF 3
APPROVED	<i>WV</i>	TITLE	SCALE
DE APPR.	<i>WV</i>	<b>CLAMP</b>	NTS
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8 7 6 5 4 3 2 1